

Work Order ID 163863

163863

Page 1

Monday, July 10, 2017 12:01:11 PM

Item ID: D3501-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 7/18/2017 Start Qty: 200.00

200

Cust Item ID:

Required Date: 7/27/2017 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date: JUL 10 2017

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3501

Rev A

100

0.12

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

4.83

200

0

DAS

33

9-89

17/07/14

Hardinge CNC Lathe Small

1-TURN AS PER FOLIO FA650 & DWG D3501 ,FOLIO

REV: 44 DWG REV: 2-DEBURR AS REQUIRED

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

2.00

200

0

DAS

33

9-89

17/07/14

Quality Control

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

4.00

200

0

DAS

49

9-89

17/07/15

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 163863

163863

Page 2

Monday, July 10, 2017 12:01:11 PM

Item ID: D3501-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bushing
 Start Date: 7/18/2017 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 7/27/2017 Req'd Qty: 200.00 *200* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>St038A</i>	0.00			<i>Windy</i>	<i>Scale 200</i>		<i>JUL 17 2017</i>	<i>DAS 6 9-89</i>
130									
Packaging	Memo	2.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	20.00							<i>17/7/18</i>
Quality Control									

DAS
21
9-89 JUL 18 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Picklist Print

Monday, July 10, 2017 12:01:07 PM

Page 1

Work Order ID: 163863

163863

Parent Item: D3501-1

D3501-1

Parent Item Name: Bushing

Start Date: 7/18/2017

Required Date: 7/27/2017

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP Rev:A New Issue 06-05-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No			100	f	56.9140	0.0791	16.65264			DAS
M303R0 750									**				33
303 Round Bar 0.750													9-89

17/07/17

Location

Loc Qty

Loc Code

MAT028

56.914

M137513

8.914

M137823

48

17, 116

DQA: _____ Date: _____



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Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
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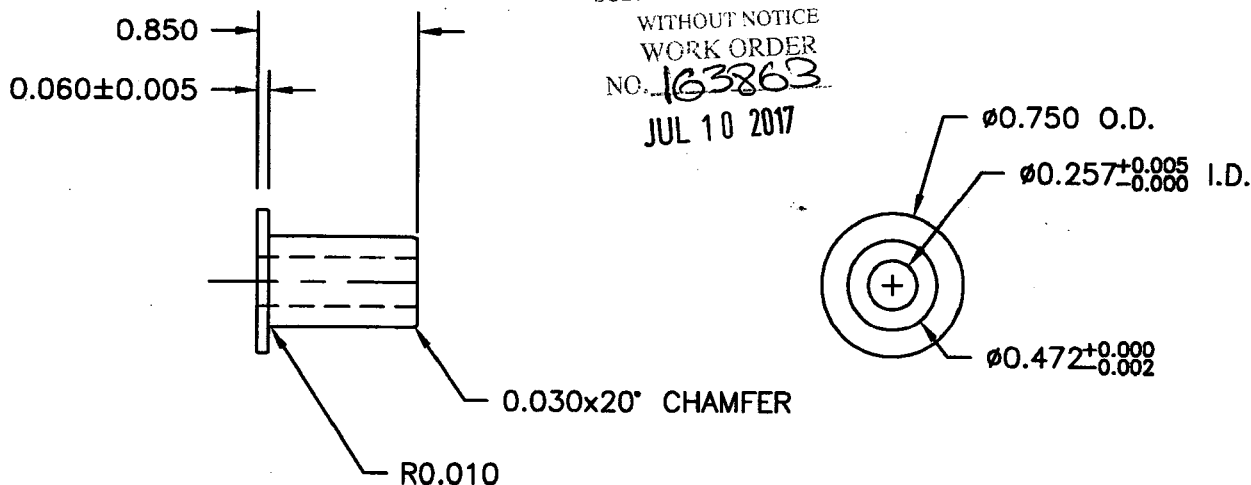
INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	
B	16.10.13	Tolerance revised on Ø0.750 dimension	KJ	

DART

DESIGN QP	DRAWN BY QP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3501	REV. A SHEET 1 OF 1
DATE 06.04.18		TITLE BUSHING	SCALE 1:1
A	06.04.18	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED CO.
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 163863
JUL 10 2017

**D3501-1 BUSHING**

- 1) MATERIAL: AISI 303 SS (REF DART SPEC. M303R)
- 2) FINISH: NONE
- 3) BREAK ALL UNMACHINED SHARP CORNERS 0.010 MAX
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.08.15 H

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